

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024890**Date Inspected:** 19-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 14, 14W (NWIT # 09516)

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3020T-102~107, 112, 113, 125

SEG3020AL-034, 036, 038, 044, 046, 050, 056, 058, 060, 275, 283, 285, 287, 289, 297, 299

SEG3020W-102, 112, 113, 114, 115, 153, 155, 158, 160, 168, 170

SEG3020R-165, 166, 167, 169, 170, 171, 201, 203, 204, 205, 206

SEG3020P-112, 113, 114, 115, 116, 117

SEG3020M-043, 044, 045, 046, 073, 074, 071, 072

This QA Inspector observed following work in progress:

BAY 14, 14WEST

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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This QA Inspector observed ZPMC qualified welding personnel identified as 068097 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam I Rib stiffener to longitudinal diaphragm weld of OBG Segment 14W. Weld joint is identified as SEG3020R-152. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 070006 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate T Rib stiffener to Floor beam weld of OBG Segment 14W. Weld joint is identified as SEG3020T-120. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067656 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as SEG3020AG-009. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066734 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam I Rib stiffener to longitudinal diaphragm weld of OBG Segment 14W. Weld joint is identified as SEG3020D-228. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2211-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art
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QA Reviewer
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